



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBEL135M-2905-101
Job Sheet 188519



Part No: RBEL135M-2905-101

Job Qty: 1 pcs

Part Name: Hydraulic Pump Drive Tool (1 unit)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/10/19

Job Tracking No:

Due Date: 2/19/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBEL135M-2905-101 REV 9 IPP REV A 18.05.24 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	2/19/19	2/19/19	0.00	0.00	Small Fab - 2		MLL
110	Small Fab - 2 - B4B	1 pcs	2/19/19	2/19/19	0.00	0.00	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 2 - B4B		MLL
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	2/19/19	2/19/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		DAS
							QC 5 - 30		30
130	Packaging 3-1 - Stock - B4B	1 pcs	2/19/19	2/19/19	0.00	0.00	Packaging 3 - 1 - B4B		9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		



Container No: S153555



Part: RBEL135M-2905-101

Job No: 188519

Serial No/Batch: S153555

Revision: 9

Inspector:

Exp Date:

Instructions:

Date: 02/14/19

					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	MLC
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DAG
140 QC 21 - FG	1 pcs	2/19/19	0.00 0.00	QC 21 - FG - 21	21 FEB 14 2019	GA
				QC 21 - FG - 70	2-59	

Part Op 110 - Small Fab - 1-Engrave placard RB41011 using MARKTRONIC engraver as per Dart QSI 044 2-Transfer drill Dart Descriptions: placard RB41011 into Pelican case APP-1605-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Pack case as per DWG.

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	110-Small Fab - 1	
APP-1605-E	Case	1 Ea (1 ea)	110-Small Fab - 1	
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	110-Small Fab - 1	
RBEL135M-2905-101-00	Hydraulic Pump Drive Tool	1 Ea (1 ea)	110-Small Fab - 1	5153464
RBEL135M-2905-101-39	Poly-V Groove Belt	1 Ea (1 ea)	110-Small Fab - 1	
RBEL135M-2905-101-57	Bottom Cushion use in case APP-1605-E	1 Ea (1 ea)	110-Small Fab - 1	
RBEL135M-2905-101-59	Top Foam use in case APP-1605-E	1 Ea (1 ea)	110-Small Fab - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	97524A032	4	759	0
	APP-1605-E	1	2	0
	RB41011	1	487	0
	RBEL135M-2905-101-00	1	2	0
	RBEL135M-2905-101-39	1	6	0
	RBEL135M-2905-101-57	1	1	0
	RBEL135M-2905-101-59	1	1	0

Part Specifications
Specifications could not be found.

Plex 1/23/19 11:48 AM Dart.Hadley.Shannon



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Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/19/19	0.00	0.00	Start Up Small Fab-4		
110	Small Fab	1 pcs		2/19/19	0.00	0.00	Small Fab-4		
120	QC	1 pcs		2/19/19	0.00	0.00	QC5		
130	Packaging	1 pcs		2/19/19	0.00	0.00	Packaging3-1		
140	QC21-FG	1 Ea		2/19/19	0.00	0.00	QC21		

Part Op 110 - 1-Engrave placard RB41011 using MARKTRONIC engraver as per Dart QSI 044 2-Transfer drill Dart placard
Descriptions: RB41011 into Pelican case APP-1605-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	90-Start up Operation	3021040
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	110-Small Fab	5113449
APP-1605-E	Case	1 Ea (1 ea)	110-Small Fab	5131424
RBEL135M-2905-101-00	Hydraulic Pump Drive Tool	1 Ea (1 ea)	110-Small Fab	5153464
RBEL135M-2905-101-39	Poly-V Groove Belt	1 Ea (1 ea)	110-Small Fab	5077692
RBEL135M-2905-101-57	Bottom Cushion use in case APP-1605-E	1 Ea (1 ea)	110-Small Fab	5131426
RBEL135M-2905-101-59	Top Foam use in case APP-1605-E	1 Ea (1 ea)	110-Small Fab	5131425

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RB41011	1	492	0
110-Small Fab	97524A032	4	474	0
	APP-1605-E	1	2	0
	RBEL135M-2905-101-00	1	0	0
	RBEL135M-2905-101-39	1	6	0
	RBEL135M-2905-101-57	1	1	0
	RBEL135M-2905-101-59	1	1	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

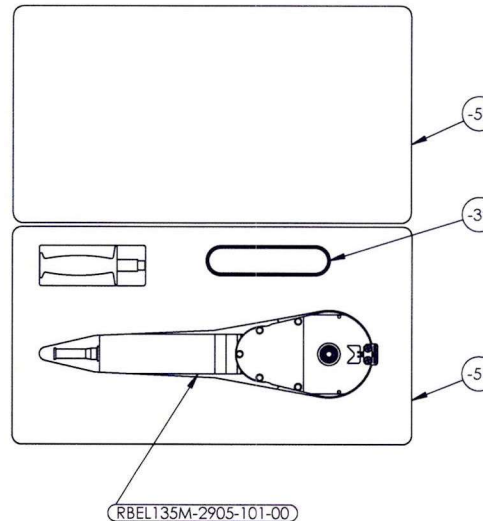
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

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WORK ORDER
NO. 188579 ML5
1901-10

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		CHANGED MOTORS FROM FLEX #13309FR TO MILWAUKEE #6116-33. ALSO CHANGED PULLEY SIZE TO ADJUST FOR THE 1200 RPM DIFFERENCE. DRIVER PULLEY -07 WAS 0.1495 NOW 0.1603, AND DRIVEN 07 WAS 0.173 NOW 0.1865. ALSO -07 0.3.671 (x2) IS NOW 0.3.779 (x2).	5/12/2010	WP	DW
2		CHANGED -13 MOTOR CLAMP TO FIT NEW MOTOR & MOVED -01 CASE M6 HOLE UP .071 FROM B.C. 0.3.206. ALSO REPLACED (3) -33 HEX HEAD CAP SCREW WITH -54 SOCKET HEAD CAP SCREW.	9/14/2010	WP	DW
2A		ADDED OPTIONAL 2 UNIT KIT WITH HARD CASE, AND CHANGED FROM 5 PAGES TO 8.	9/16/2010	WP	
3		ADDED COMPARTMENT FOR HANDLES TO -101-43 PER D.W.	12/10/2010	RJC	RW
4		CHD -25 QTY. FROM 1 TO 2. LABELED -01 SECTION C-C. CHD -05 COUNTERSINK FROM 0.276 TO 0.310. CHD -07 0.17mm TO 0.6688 +.0005 -.0000. ADDED -07 (1.414) DIM. CHD -13 CUT REF. DIM. FROM .08 & .076 TO .093. ALL CHANGES PER G.E.	12/29/2010	RJC	RW
5		ADDED -00 ASSY. 2 EA. TO BOM. DOUBLED ALL BUYOUT QUANTITIES. DELETED RBEL135M2905-101-B. CHD -05 DIM. FROM 0.267 P.F. -23 TO LIMIT DIM. 2666 - .2660. ADDED -11 & -07 NICKLE PLATE THICKNESS .0004 - .0006. ADDED -19 NICKLE PLATE THICKNESS .0004 - .0006. CHD -19 DIM. FROM .392 S.F. -21 TO LIMIT .3914 - .3905. ADDED -21 NICKLE PLATE THICKNESS .0004 - .0006. CHD -21 DIM. FROM .393 S.F. -19 TO LIMIT DIM. .3944 - .3930. CHD -23 DIM. FROM BASIC .267 TO 0.2674 - .2670.	12/20/2012	RJC	SE
5A		-05 DELETED 0.3.149. SEPERATED PARTS ONTO INDIVIDUAL PAGES.	2/26/2013	BIM	GE
6		ADDED PARTS -14 & -42 FOR USE WITH GRINDER MODEL MILWAUKEE #6117-33. ADDED NOTES 3 & 4 SHEET 1. ADDED NOTES 1 & 2 SHEET 2. REDRAWN WAS AUTO CAD IS SOLIDWORKS.	7/29/2013	CFS	DW
7		CHD P/N WAS RBEL135M2905-101 IS RBEL135M-2905-101. -21 CHD CORNER WAS NO RADIUS IS 2X R.13.	10/9/2013	CFS	GE
8		-17 CHD DIMENSION WAS 50.46 IS 50.50. -17 CHD DIMENSION WAS 1.181 IS 1.18.	6/16/2014	DJN	GE
9	16-0222	DELETED NOTES 3, 4, & 5 SHEET 1. DELETED NOTES 1 & 2 SHEET 2. CHD HYDRAULIC PUMP DRIVE TOOL ASSY. TO -00 & CHD QTY WAS 2 IS 1. -01 CHD DIM WAS 2X 0.30mm 0.276 P.F. -27 IS 2X 0.1.180/1.179 0.279 (P.F. -27). ADDED THREAD FIT. -03 CHD DIM WAS (1.25) IS .13, WAS (2X 1.39) IS 2X 1.29. -05 CHD DIM WAS 0.2666/2660 IS 0.2666/2660 (P.F. -29). -07, -19, -21 CHD MATERIAL WAS 1018 IS 1018/1020 CR. -07, -11, -19, -21 CHD FINISH WAS NICKLE PLATE IS ZINC PLATE ASTM B633 TYPE 1 SC2. -11 CHD DIM WAS 276 IS 2X 276. WAS 2X 0.250 THRU ALL. 0.462 X 90° IS 2X 0.25 THRU ALL. 0.48 X 90° CHD MATERIAL WAS 1018 IS 434/1018/1020 HR. 13 CHD DIM WAS 09 CUT RELIEF IS 09 TWO INSTANCES. -14 CHD DIM WAS 09 CUT REF. IS 09. DELETED NOTE 1. -15 CHD DIM WAS 2X 0.0786/0782 THRU IS 2X 0.0786/0782 THRU ALL (P.F. -53). -17 CHD DIM WAS M8X1.25 IS (M8X1.25). -19 CHD DIM WAS .195 IS 3X .165. -21 CHD DIM WAS .276 IS 2X .276. DELETED DIM 0.217. ADDED DIM. 217. 2X FULL R. -23 CHD DIM WAS 0.2674/2670 IS 0.2674/2670 (P.F. -05). -39 CHD ASSY QTY. WAS 2 IS 1 ADDED QTY. 1 FOR SPARE. -41 DELETED. -43 CHD B/O P/N WAS MILWAUKEE #6116-33 IS MILWAUKEE #6117-33. -57 CHD FOAM SIZE FOR NEW CASE #APP-1605-E. AND LAYOUT CONFIGURATION FOR ONE-00 HYDRAULIC PUMP DRIVE TOOL. -59 CHD FOAM SIZE FOR NEW CASE #APP-1605-E. -61 RB41009 IS RB41011. -65, -57, -59 CHD DIM TO SHEET METAL TOLERANCE.	11/23/2016	RJC	SM

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PQ.
	X		-00	1	HYDRAULIC PUMP DRIVE TOOL			2
	1		-01		CASE	6061		3
	1		-03		BOTTOM COVER	6061		4
	1		-05		TOP COVER	6061		5
	1		-07		GEARED PULLEY	1018/1020 CR		6
	1		-09		DRIVE PULLEY	6061		7
	1		-11		CLAMP TOP	A36/1018/1020 HR		8
	1		-13		MOTOR CLAMP	6061		9
	1		-14		COLLAR	6061		10
	1		-15		CLAMP	6061		11
	1		-17		THUMB SCREW	S.S.	M8 X 1.25 X 30mm (J.W. WINCO #8N30F485) MODIFIED	12
	2		-19		SLIDE GUIDE	1018/1020 CR		13
	2		-21		SLIDE	1018/1020 CR		14
	1		-23		PIN		303/304	15
	2	B/O	-25		THREADED KNOB		M5 X .08 X 16mm (J.W. WINCO #5N14DD1)	2
	2	B/O	-27		BEARING		6903RU (MCMASTER-CARR #5972K289)	2
	2	B/O	-29		FLAT HEAD MACHINE SCREW	STEEL	M4 X 0.7 X 10mm (MCMASTER-CARR #91420A220)	2
	2	B/O	-31		FLAT HEAD MACHINE SCREW	STEEL	M4 X 0.7 X 8mm (MCMASTER-CARR #91420A218)	2
	10	B/O	-33		HEX HEAD CAP SCREW	STEEL	M6 X 1 X 10mm (MCMASTER-CARR #91280A322)	2
	13	B/O	-35		FLAT WASHER	STEEL	06mm (MCMASTER-CARR #91166A250)	2
	1	B/O	-37		EXTERNAL SNAP RING	S.S.	017mm (SHAFT) (MCMASTER-CARR #90967A210)	2
	1	B/O	-39	1	POLY-V GROOVE BELT	NEOPRENE	180J4 (MCMASTER-CARR #9003K41)	2
	1	B/O	-42		FLAT WASHER	STEEL	05/8 X .063 thick (AIRCRAFT SPRUCE #AN960-1016)	2
	1	B/O	-43		SMALL ANGLE GRINDER MOTOR		MILWAUKEE #6117-33	2
	1	B/O	-45		ARROW EMBLEM	VINYL	1/16 X 1/2 X 2-1/2 (SIGNS NOW)	16
	1	B/O	-47		HEX HEAD CAP SCREW	STEEL	M8 X 1.25 X 25mm (MCMASTER-CARR #91280A534)	2
	1	B/O	-49		FLAT WASHER	STEEL	08mm (MCMASTER-CARR #91166A270)	2
	2	B/O	-51		FLAT HEAD MACHINE SCREW	STEEL	M6 X 1 X 25mm (MCMASTER-CARR #91420A430)	2
	2	B/O	-53		DOWEL PIN	S.S.	02mm X 12mm (MCMASTER-CARR #91585A010)	2
	3	B/O	-54		SOCKET HEAD CAP SCREW	S.S.	M6 X 1 X 10mm (MCMASTER-CARR #91292A441)	2
		B/O	-55	1	CASE	PLASTIC	PELICAN #APP-1605-E	N/S
		B/O	-57	1	BOTTOM TOOL CUSHION	ETHAFOAM 220, BLACK	6.39 X 14.45 X 26.45 (CASE SOLUTIONS)	17
		B/O	-59	1	TOP FOAM	ETHAFOAM 220, BLACK	2.01 X 14.52 X 26.35 (CASE SOLUTIONS)	18
		B/O		1	DART PLACARD	ALUMINUM	RB41011	N/S
	ASSY -00							



- NOTES:
1. RBEL135M-2905-101 REPLACES EUROCOPTER TOOL NO. L135M2905-101.
 2. OPTIONAL HARD CASE WITH 2 HYDRAULIC PUMP DRIVE TOOLS CAN BE PURCHASED SEPERATELY. RBEL135M-2905-101-M.

DART AEROSPACE																																	
TITLE HYDRAULIC PUMP DRIVE TOOL																																	
DWG NO. RBEL135M-2905-101	REV 9																																
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